



Dart Aerospace Ltd.
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646.3511

Job Sheet 191985



Part No: 646.3511

Job Qty: 20 pcs

DAS
21
9-89

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/14/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs		4/15/19	0.00	0.81	Waterjet - Flow		OK 19/05/22
120	QC 2	20 pcs		4/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		OK 19/05/22
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



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Container No: S183035



Part: 646.3511

Job No: 191985

Serial No/Batch: S183035

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/10/19

130 QC 8	20 pcs	4/15/19	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
140 Small Fab - 2 - B4B	20 pcs	4/15/19	0.00 8.40	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	20 pcs	4/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Large Fab - Welded Assy-2-B4B	20 pcs	4/15/19	0.00 22.99	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	

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ML

a

ML

				Large Fab - 9 - B4B	
170 QC 9	20 pcs	4/15/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	B
				QC 9 - 9	
180 QC 5	20 pcs	4/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	B
				QC 5 - 30	
				QC 5 - 40	
220 Spray Paint - 2 - B4B	20 pcs	4/15/19	0.00 0.92	Spray Paint - 1 - B4B	RD 19-6-18
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
225 Outsource - 11 - Paint	20 pcs	4/15/19		ATE003-VC	5
230 QC 14	20 pcs	4/15/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
240 Packaging 3-1 - Stock - B4B	20 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	9-89 74 DAS JUN 1 2019
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 -	

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				B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
250	QC 21 - SA	20 pcs	4/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Small Fab - 1- Fabricate tube as per dwg USE DT10290 PUNCH 150 - QC5- Inspect part completeness to step on W/O 160 - Weld per dwg A/R S.S. rod Batch: _____ - Weld tube to plate as per dwg. DT9867 170 - QC9- Inspect visual per QSI004- Fusion Welds 180 - QC5- Inspect part completeness to step on W/O 220 - Spray Paint / NDT Room - Prime as per dwg (see note 3)					

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230 - QC14- Inspect Spray Paint

240 - Identify as per dwg & Stock Location: _____ - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

250 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5560 sf (.0278 ea)	110-Waterjet - Flow - 1	
M304TR0.500W.049	304 Round Tube .500 X .049W	16.6600 ft (.833 ea)	140-Small Fab - 2 - B4B	5166227

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	1	313	0
140-Small Fab - 2 - B4B	M304TR0.500W.049	17	86	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches $\pm$ 0.030	2.780 2.720		2.750
2	Strut	1.500Inches $\pm$ 0.030	1.530 1.470		1.500
3	Strut	0.063Inches $\pm$ 0.010	0.073 0.053		0.061

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

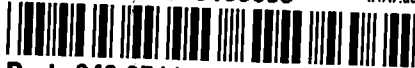
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Date: 05/22/19